

Work Order ID 155020

Monday, March 06, 2017 1:19:25 PM

155020

Page 1

Item ID: D119-646-111 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: URF 15-560 Stop ***NS2***
Item Name: AW119 Skidtube with Standard Wearplates & Wearpads - LH
Start Date: 3/7/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 3/21/2017 Req'd Qty: 1.00 ***1*** Customer:
Reference: SCHEDULED

Approvals: Process Plan:  Date: MAR 06 2017 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D119-646	C	MAR 22 2017							

100

0.00

100

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPP D119-646-111
CHG004DAS
28
9-89

MAR 28 2017

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

DAS
6
9-89

MAR 27 2017

DAS
27
9-89

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

DAS
28
9-89

MAR 28 2017

B155017

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Work Order ID 155020

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155020

Page 2

Item ID: D119-646-111 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: URF 15-560 Stop ***NS2***
Item Name: AW119 Skidtube with Standard Wearplates & Wearpads - LH
Start Date: 3/7/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 3/21/2017 Req'd Qty: 1.00 ***1*** Customer:
Reference: SCHEDULED

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

0.00

130

Packaging

Memo

0.00

Identify and pack for shipping as per PPP D119-646-111

Location: F9087
PPP rev: _____DAS
28
9-89DAS
27
9-89

MAR 28 2017

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

17/3/30



MAR 29 2017

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
OTHER : ☐									

Picklist Print

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Page 1

Work Order ID: 155020

155020

Parent Item: D119-646-111

D119-646-111

Parent Item Name: AW119 Skidtube with Standard Wearplates & Wearpads - LH

Start Date: 3/7/2017

Required Date: 3/21/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: New issue DD verified by:EC
12.11.05 raise to chg002 (ECN 12-675) DD verf:JLM IPP REV:C 13.03.20
raise to chg003 (ECN 13-534) DD verf:JLM IPP REV:D 14.11.25 IIN REV.C
(ECN 14-628) DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D119-646-141		Manufactured	No			110	Each	0.0000	1	1			
D119-646-141									**	155017			DAS 27 9-89
AW119 Replacement Skidtube with Standard Wearplates & Wearpads, Fits LH & RH													
D119-646-311		Manufactured	No			110	Each	5.0000	1	1			
D119-646-311									**	MAR 27 2017			DAS 27 9-89
Ground Handling													
				<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>							
				ST636a	5								
				152317	2								
				155608	3								
D3883-1		Manufactured	No			110	Each	19.0000	2	2			
D3883-1									**	MAR 27 2017			DAS 27 9-89
Saddle, Outboard LH													
				<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>							
				ST404	19								
				153045	5								
				153815	14								
D3884-1		Manufactured	No			110	Each	15.0000	2	2			
D3884-1									**	MAR 27 2017			DAS 27 9-89
Saddle, Inside LH													
				<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>							
				ST403	10								
				153739	10								
				ST404	5								
				152921	5								

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QS1042) Approval	
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
OTHER : ☐									

Picklist Print

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Work Order ID: 155020

155020

Parent Item: D119-646-111

D119-646-111

Parent Item Name: AW119 Skidtube with Standard Wearplates & Wearpads - LH

Start Date: 3/7/2017

Required Date: 3/21/2017

Start Qty: 1.00

Required Qty: 1.00

D2652 Manufactured No 110 Each 725.0000 16 16

D2652

Bushing

**

MAR 27 2017

DAS 6 9-89

DAS 27 9-89

Location Loc Qty Loc Code

FG	44	
31985	44	
ST009	481	
153807	481	10
ST012a	200	
154965	200	

AN3C50A Purchased No 110 Each 248.0000 8 8

AN3C50A

Bolt

**

MAR 27 2017

DAS 6 9-89

DAS 27 9-89

Location Loc Qty Loc Code

OVER002	200	
M136503	200	8
ST346	48	
M136348	48	

AN4C6A Purchased No 110 Each 373.0000 12 12

AN4C6A

Bolt

**

MAR 27 2017

DAS 6 9-89

DAS 27 9-89

Location Loc Qty Loc Code

FG	14	
103344	4	
121657	10	
OVER002	128	
m136318	128	
ST345	231	
m136047	231	12

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date: _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By _____	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
OTHER : _____									

Picklist Print

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Page 3

Work Order ID: 155020

155020

Parent Item: D119-646-111

D119-646-111

Parent Item Name: AW119 Skidtube with Standard Wearplates & Wearpads - LH

Start Date: 3/7/2017

Required Date: 3/21/2017

Start Qty: 1.00

Required Qty: 1.00

MS21250-05-006

Purchased

No

110

Each

38.0000

8

8

MS21250-05-006

BOLT

**

DAS
6
9-89

DAS
27
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

FG

10

124291

10

ST295

28

M133234

28

110

Each

3,791.000

8

8

NAS1149C0332R

Purchased

No

NAS1149C0332R

WASHER

**

MAR 27 2017

137074x4

4

MAR 9 2017

DAS
6
9-89

DAS
27
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

FP001

182

m126319

54

m127831

54

m136537

28

m136741

46

GA

532

m133284

32

m136444

500

ST260a

2700

m135408

0

m135766

500

m135908

200

m136042

500

m136643

1000

m136975

500

ST266

377

m135466

377

MAR 27 2017

MAR 27 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date: _____		Step #: _____		QTY Effective : _____				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
		OTHER : _____							

Picklist Print

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Work Order ID: 155020

155020

Parent Item: D119-646-111

D119-646-111

Parent Item Name: AW119 Skidtube with Standard Wearplates & Wearpads - LH

Start Date: 3/7/2017

Required Date: 3/21/2017

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0432R

Purchased

No

110

Each

1,010.000

24

24

NAS1149C0432R

WASHER

DAS
28
9-89

Location

Loc Qty

Loc Code

GA

373

m134676

373

ST266

637

m136182

637

110

Each

448.0000

8

8

NAS1149C0532R

Purchased

No

NAS1149C0532R

WASHER

DAS
28
9-89

Location

Loc Qty

Loc Code

FP001

54

m135390

54

GA

42

116513

42

ST260a

200

m136192

200

ST266

152

m135966

52

m136983

100

DAS
6
9-89

MAR 27 2017

DAS
27
9-89

DAS
6
9-89

MAR 27 2017

DAS
27
9-89

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
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Root Cause		FAULT CATEGORY																																																													
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____	
Misidentified ☐	Past Due ☐																																																														

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Parent Item: D119-646-111

D119-646-111

Parent Item Name: AW119 Skidtube with Standard Wearplates & Wearpads - LH

Start Date: 3/7/2017

Required Date: 3/21/2017

Start Qty: 1.00

Required Qty: 1.00

MS21043-3

Purchased

No

110

Each

789.0000

8

8

MS21043-3

Nut

DAS
28
9-89

Location

Loc Qty

Loc Code

FG	80	
103691	80	
FP001	203	
m130673	11	
m136182	192	
GA	215	
m133990	27	
m136182	188	
ST302	222	
m136295	222	
ST304	69	
m131340	69	

126741

MAR 27 2017

DAS
27
9-89

MS21043-4

Purchased

No

110

Each

1,107.000

13

13

MS21043-4

Nut

DAS
28
9-89

Location

Loc Qty

Loc Code

FG	40	
104603	40	
GA	17	
m132803	17	
OVER007	600	
m136406	300	
m136983	300	
ST302	450	
m136148	4	
m136192	146	
m136263	300	

13

MAR 27 2017

DAS
27
9-89

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				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : ☐	

Picklist Print

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Page 6

Work Order ID: 155020

155020

Parent Item: D119-646-111

D119-646-111

Parent Item Name: AW119 Skidtube with Standard Wearplates & Wearpads - LH

Start Date: 3/7/2017

Required Date: 3/21/2017

Start Qty: 1.00

Required Qty: 1.00

D2712 Manufactured No 110 Each 449.0000 12 12
D2712 **
Set Screw

MAR 27 2017
DAS 6 27
9-89 9-89

DAS
28
9-89

Location	Loc Qty	Loc Code
FG	50	
29962	50	
ST010	199	
152321	50	
152870	29	
<u>153921</u>	60	12
154871	50	
89929	10	
ST012a	200	
153570	200	

D3672-7 Manufactured No 110 Each 1,254.000 24 24
D3672-7 **
Washer, Phenolic

MAR 27 2017
DAS 6 27
9-89 9-89

DAS
28
9-89

Location	Loc Qty	Loc Code
FG	40	
129987	25	
133986	15	
ST049	214	
152458	214	
ST051A	1000	
<u>153039</u>	500	24
157442	500	

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Page 6

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

Picklist Print

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Work Order ID: 155020

155020

Parent Item: D119-646-111

D119-646-111

Parent Item Name: AW119 Skidtube with Standard Wearplates & Wearpads - LH

Start Date: 3/7/2017

Required Date: 3/21/2017

Start Qty: 1.00

Required Qty: 1.00

D3672-3

Manufactured No

110

Each

1,238.000

24

24

D3672-3

Washer, Phenolic

★★

MAR 27 2017

DAS 27 9-89

DAS 28 9-89

Location

Loc Qty

Loc Code

FG

100

133083

52

134449

48

FP001

197

132639

197

ST049

441

153292

441

ST051A

500

149295

0

153930

500

24

D3407-041

Manufactured No

110

Each

29.0000

1

1

D3407-041

Tow Ring

★★

MAR 27 2017

DAS 27 9-89

DAS 28 9-89

Location

Loc Qty

Loc Code

st530

29

150908

5

153698

9

155492

15

1

D3417-5

Manufactured No

110

Each

113.0000

2

2

D3417-5

Washer

★★

MAR 27 2017

DAS 27 9-89

DAS 28 9-89

Location

Loc Qty

Loc Code

ST034

33

152860

33

ST038A

80

151493

40

156835

40

2

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Shop Packet Print

Page 7

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date: _____		Step #: _____		QTY Effective : _____				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					

Root Cause			FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence
Past Expiry Date	☐	Manufacturing Process	OTHER : _____							
Misidentified	☐	Past Due								

Picklist Print

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Work Order ID: 155020

155020

Parent Item: D119-646-111

D119-646-111

Parent Item Name: AW119 Skidtube with Standard Wearplates & Wearpads - LH

Start Date: 3/7/2017

Required Date: 3/21/2017

Start Qty: 1.00

Required Qty: 1.00

D3456-1

Manufactured No

110

Each

137.0000

1

1

D3456-1

Washer

MAR 27 2017

DAS
27
9-89

DA
6
9-8

DAS
28
9-89

Location

Loc Qty

Loc Code

FG	7	
25701	7	
ST037	55	
152842	29	
154870	25	
155548	1	
ST038A	75	
156723	25	
157166	50	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Item	Qty -011	Qty -012	Qty -111	Qty -112	Qty -211	Qty -212	Qty -041	Qty -141	Qty -151	Qty -241	Qty -251	Qty -311	Part Number	Description
69	24	24	24	24	24	24							AN960C418L	WASHER (OR NAS1149C0432R)
70	8	8	8	8	8	8							AN960C518L	WASHER (OR NAS1149C0532R)
71	8	8	8	8	8	8							MS21043-3	NUT
72	12	12	12	12	12	12							MS21043-4	NUT
73	12	12	12	12	12	12							D2712	SET SCREW
74	16	16	16	16	16	16							D3672-7	WASHER
75	24	24	24	24	24	24							D3672-3	WASHER
76	8	8	8	8	8	8							D3672-7	WASHER
80	1	1	1	1	1	1							D3407-041	TOW RING
81	2	2	2	2	2	2							D3417-5	WASHER
82	1	1	1	1	1	1							D3456-1	WASHER
83	1	1	1	1	1	1							MS21043-4	NUT
90												2	D3886-041	LUG ASSEMBLY
91												8	D2652	BUSHING
92												4	AN3C46A	BOLT
93												4	AN960C10L	WASHER (OR NAS1149C0332R)
94												4	MS21043-3	NUT

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Revision: C
Date: 13.08.16

6.0 PARTS LIST

REFERENCE ONLY

6.1 Standard Skidtubes

Item	Qty -011	Qty -012	Qty -111	Qty -112	Qty -211	Qty -212	Qty -041	Qty -141	Qty -151	Qty -241	Qty -251	Qty -311	Part Number	Description
	X												D119-646-011	STANDARD SKIDTUBE INSTALLATION WITH WEARPADS, LH
		X											D119-646-012	STANDARD SKIDTUBE INSTALLATION WITH WEARPADS, RH
			X										D119-646-111	STANDARD SKIDTUBE INSTALLATION WITH FULL LENGTH WEARPLATES & WEARPADS, LH
				X									D119-646-112	STANDARD SKIDTUBE INSTALLATION WITH FULL LENGTH WEARPLATES & WEARPADS, RH
					X								D119-646-211	STANDARD SKIDTUBE INSTALLATION WITH TRAINING WEARPLATES, LH
						X							D119-646-212	STANDARD SKIDTUBE INSTALLATION WITH TRAINING WEARPLATES, RH
	1	1					X						D119-646-041	REPLACEMENT STANDARD SKIDTUBE WITH WEARPADS
			1	1				X					D119-646-141	REPLACEMENT STANDARD SKIDTUBE WITH FULL LENGTH WEARPLATES & WEARPADS
									X				D119-646-151	WEARPLATE KIT STANDARD SKIDTUBE
					1	1				X			D119-646-241	REPLACEMENT STANDARD SKIDTUBE WITH TRAINING WEARPLATES
											X		D119-646-251	TRAINING WEARPLATES STANDARD SKIDTUBE
	1	1	1	1	1	1						X	D119-646-311	GROUND HANDLING KIT
1							1						D3887-041	STANDARD SKIDTUBE ASSY. WITH WEARPAD
20								1					D3887-043	STANDARD SKIDTUBE ASSY. WITH WEARPLATE & WEARPAD
26									1				D3847-043	FWD WEARPLATE ASSY
27									1				D3847-045	CENTER WEARPLATE ASSY
28									1				D3847-047	AFT WEARPLATE ASSY
29									5				D3847-1	WEARPAD
30									1				D3847-11	WEARPAD
31									30				AN3C5A	BOLT
32									30				AN960C10L	WASHER (OR NAS1149C0332R)
40										1			D3887-045	STANDARD SKIDTUBE ASSY. TRAINING WEARPLATE
44											1		D3849-041	FWD TRAINING WEARPLATE ASSY
45											1		D3849-043	AFT TRAINING WEARPLATE ASSY
51											16		D3904-1	WASHER
52											8		AN3C46A	BOLT
53											8		MS21043-3	NUT
60	2		2		2								D3883-1	SADDLE, OUTSIDE, LH
61		2		2		2							D3883-2	SADDLE, OUTSIDE, RH
62	2		2		2								D3884-1	SADDLE, INSIDE, LH
63		2		2		2							D3884-2	SADDLE, INSIDE, RH
64	16	16	16	16	16	16							D2652	BUSHING
65	8	8	8	8	8	8							AN3C50A	BOLT
66	12	12	12	12	12	12							AN4C6A	BOLT
67	8	8	8	8	8	8							MS21250-05006	BOLT
68	8	8	8	8	8	8							AN960C10L	WASHER (OR NAS1149C0332R)

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Revision: C
Date: 13.08.16

Work Order ID 155020

Wednesday, March 22, 2017 8:41:24 AM

155020

Page 1

Item ID: D119-646-111 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: URF 15-560 Stop ***NS2***
Item Name: AW119 Skidtube with Standard Wearplates & Wearpads - LH
Start Date: 3/22/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 4/5/2017 Req'd Qty: 1.00 ***1*** Customer:
Reference: SCHEDULED

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
IIN-D119-646	C

100

0.00

100

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPP D119-646-111
CHG004

DAS 21 MAR 22 2017

8:50 MAR 22 2017

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control